

Date: Wednesday, 3/21/2007 3:48:38 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31420	
Estimate Number : 12786	
P.O. Number : N/A	Part Number : D35645
This Issue : 3/21/2007 S.O. No. :	Drawing Number : D3564 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31136	Material : N/A
Written By : <u>                    </u>	Due Date : 3/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est Rev:A New Issue 07-03-08 ec	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 1.1099 sf(s)/Unit Total : 11.0985 sf(s)  
 M304S16GA Stainless steel sheet 0.063" thick  
 Batch: H101873

SAD 07/03/24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3564  
 Dwg Rev: A  
 Prog Rev: A

2-Deburr if necessary

SAD 07/03/24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/24

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/03/24

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE  
 Deburr if necessary  
 Form on Brake as per Dwg D3564 using Jigs DT and DT  
 Form Joggle as per Dwg D3564 on brake using Jig DT

MF 07-03-30 - (10)  
 S/B 07/04/02 (10)  
 LCM 07/03/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:48:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31420

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*20704.02*



Comment: INSPECT WORK TO CURRENT STEP  
Ensure joggle as per dwg D3429

7.0

POWDER COATING

POWDER COATING



*M/01601*



Comment: POWDER COATING  
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*5x*

*07/04/03 (18)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/04/04 (18)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*07/04/04 (18)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/04/05 (10)*

Job Completion



*U 07/04/04*

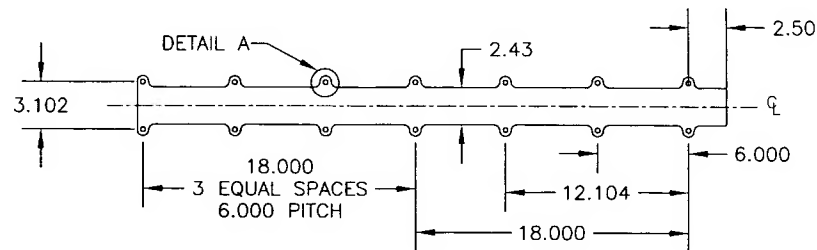
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

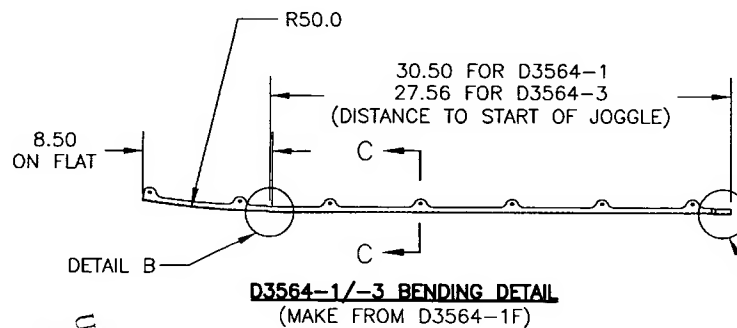
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

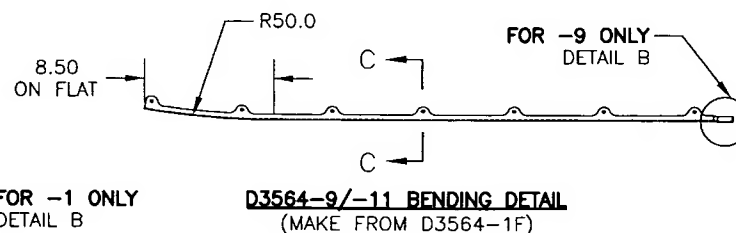
NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

**D3564-1/-3/-9/-11 WELDING DETAIL**

NO. 31420  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

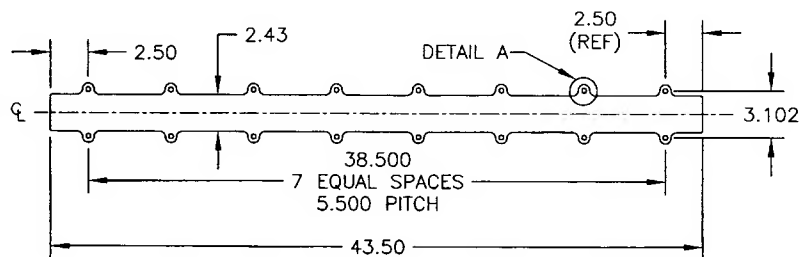
RELEASED  
07-07-28

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

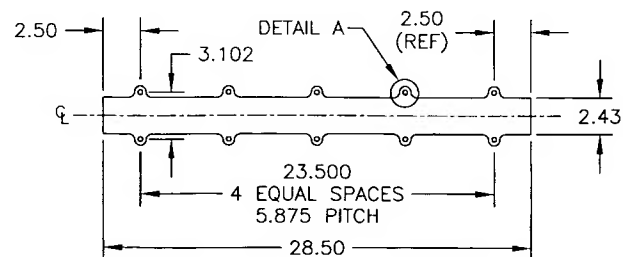
- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

A		06.12.18	NEW ISSUE	
DESIGN	PH	DRAWN BY	PH	<b>DART</b> DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3564
DATE	06.12.18	TITLE	WEARSHOE	REV. A SHEET 1 OF 2 SCALE 1:8

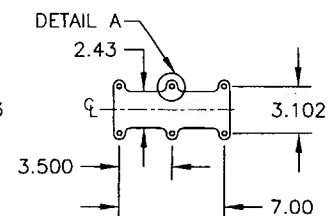
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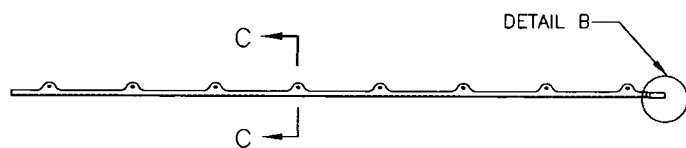
**D3564-5F FLAT PATTERN**



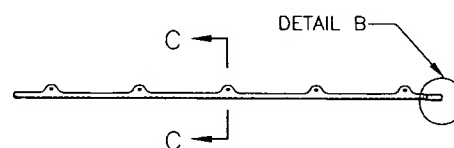
**D3564-7F FLAT PATTERN**



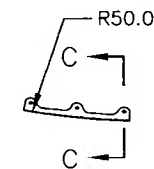
**D3564-13F FLAT PATTERN**



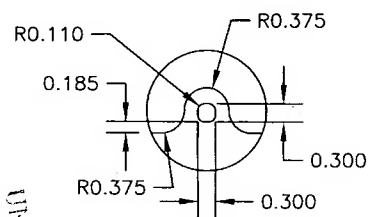
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



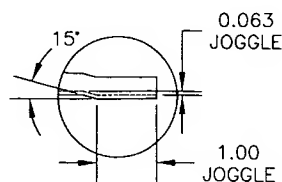
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



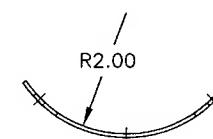
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

RELEASED

07 02 28

NO. 31420  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
SUBJECT TO ATTENDMENT

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DART AEROSPACE LTD.

DESIGN RH	DRAWN BY RH	<b>DART</b>	DART AEROSPACE LTD. WARRICKSBURY, OXFORD, ENGLAND
CHECKED #	APPROVED #	DRAWING NO. D3564	REV. A SHEET 2 OF 2
DATE 06.12.18		TITLE WEARSHOE	SCALE 1:8

DART AEROSPACE LTD		Work Order: 31420
Description: <del>Wearplate</del> wear shoe		Part Number: D35645
Inspection Dwg: D35645 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST



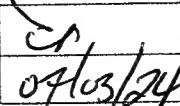
First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 43.50	$\pm 0.030$	43.50	✓		M-T/Vern	
B 5.500 (pitch)	$\pm 0.010$	5.495	✓		Vern	
C 3.102	$\pm 0.010$	3.099	✓		Vern	
D 2.50	$\pm 0.030$	2.50	✓		Vern	
E 2.43	$\pm 0.030$	2.43	✓		Vern	
F 2.50	$\pm 0.030$	2.498	✓		Vern	
G 0.300	$\pm 0.010$	0.307	✓		Vern	
H 0.300	$\pm 0.010$	0.303	✓		Vern	
I 0.063	$\pm 0.010$	0.068	✓		Vern	
J R0.375	$\pm 0.010$	R0.375	✓		R-G	
K R0.110	$\pm 0.010$	R0.110	✓		R-G	
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD
Date: 07/03/24

Audited by: 
Date: 07/03/24

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	